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D350-591-133
Job Sheet 174970



Part No: D350-591-133

Job Qty: 4 ea

Part Name: AFT Maintenance Step, Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/23/18

Job Tracking No:

Due Date: 4/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSI9712 REV A , IIN-D350-591 REV H , D2946 REV B IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	4/12/18	4/12/18	0.00	0.00	Start Up Large Fab-4		DL 2018-04-03
110	Large Fab	4 pcs	4/12/18	4/12/18	0.00	2.78	Large Fab 8		SL
120	QC	4 pcs	4/12/18	4/12/18	0.00	0.00	QC6		CPL
130	Large Fab	4 pcs	4/12/18	4/12/18	0.00	2.78	Large Fab 2		
140	QC	4 pcs	4/12/18	4/12/18	0.00	0.00	QC9		CPL
150	QC	4 pcs	4/12/18	4/12/18	0.00	0.00	QC5		CPL
160	HandFinish	4 pcs	4/12/18	4/12/18	0.00	0.61	HandFinish1		SA 15-04-06
170	QC	4 pcs	4/12/18	4/12/18	0.00	0.00	QC7-2		38
180	Large Fab	4 pcs	4/12/18	4/12/18	0.00	2.78	Large Fab 2		SL
190	QC	4 pcs	4/12/18	4/12/18	0.00	0.00	QC10		CPL
200	QC	4 pcs	4/12/18	4/12/18	0.00	0.00	QC5		CPL
210	HandFinish	4 pcs	4/12/18	4/12/18	0.00	0.61	HandFinish1		SA 15-04-09
220	Powdercoat	4 pcs	4/12/18	4/12/18	0.00	0.41	Powdercoat1		SK 18-4-10
230	HandFinish	4 pcs	4/13/18	4/13/18	0.00	0.61	HandFinish3		BEDAS-04-10
240	QC	4 pcs	4/13/18	4/13/18	0.00	0.00	QC3		11 APR 12 2018
250	Packaging	4 pcs	4/13/18	4/13/18	0.00	0.00	Packaging1-3		APR 13 2018
260	QC	4 pcs	4/13/18	4/13/18	0.00	0.00	QC4		
265	DC	4 pcs	4/13/18	4/13/18	0.00	0.00	DC		
270	Packaging	4 pcs	4/13/18	4/13/18	0.00	0.00	Packaging3-1		
280	QC21-FG	4 Ea	4/13/18	4/13/18	0.00	0.00	QC21		APR 13 2018

Part Op 110 - 1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

Descriptions: 130 - 1-Deburr and Bevel ends for welding Use DT8440 jig

180 - Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.

220 - START TIME: 11:20 AM 1:30 PM FINISH: 1:00 PM 1:45 PM

265 - Photocopy bluefile and type labels as per PPP D350-591-133 CHG004

270 - Identify and pack for shipping as per PPPD350-591-133 Location: F9038

M138761

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2.0800 Ea (.52 ea)	90-Start up Operation	5046116
D2734	Step End Plate	8 Ea (2 ea)	130-Large Fab	3612001
D2944	Step Mounting Plate	8 Ea (2 ea)	130-Large Fab	3164736
AN4-11A	Bolt	16 Ea (4 ea)	250-Packaging	3017090

AN4-16A	Bolt	32 Ea (8 ea)	250-Packaging	5041125
AN4-7A	Bolt	8 Ea (2 ea)	250-Packaging	FM137820
D2230-1	Mounting Lug	16 Ea (4 ea)	250-Packaging	5059886
D2230-3	Mounting Lug	16 Ea (4 ea)	250-Packaging	5051382
D2732	Rubber Cushion (SPer Foot)	8 Ea (2 ea)	250-Packaging	5044807
D2945	Mounting Plate	4 Ea (1 ea)	250-Packaging	7161697X3 5054561X1
D3338-1	Mounting Lug	4 Ea (1 ea)	250-Packaging	5026722
MS21042L4	Nut	56 Ea (14 ea)	250-Packaging	5045901
NAS1149D0463J	Washer	56 Ea (14 ea)	250-Packaging	5045845

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	2	216	0
130-Large Fab	D2734	8	19	0
	D2944	8	16	0
250-Packaging	AN4-11A	16	143	0
	AN4-16A	32	181	0
	AN4-7A	8	73	0
	D2230-1	16	4	0
	D2230-3	16	191	0
	D2732	8 32.	509	0
	D2945	4	3	0
	D3338-1	4	33	0
	MS21042L4	56	3,350	0
	NAS1149D0463J	56	3,385	0
Part Specifications				
Specifications could not be found.				



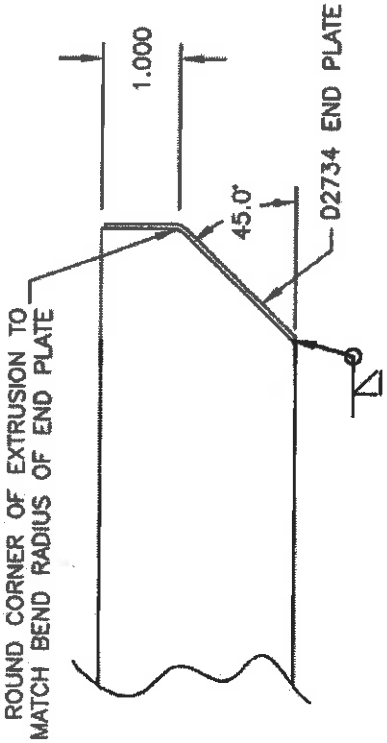
DESIGN CP	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2946	REV. B SHEET 1 OF 1
DATE 05.11.14	TITLE STEP ASSEMBLY		SCALE 1:6
A	99.12.13	NEW ISSUE	
B	05.11.14	UPDATE FINISHING NOTE	

D2946 STEP ASSEMBLY PARTS LIST

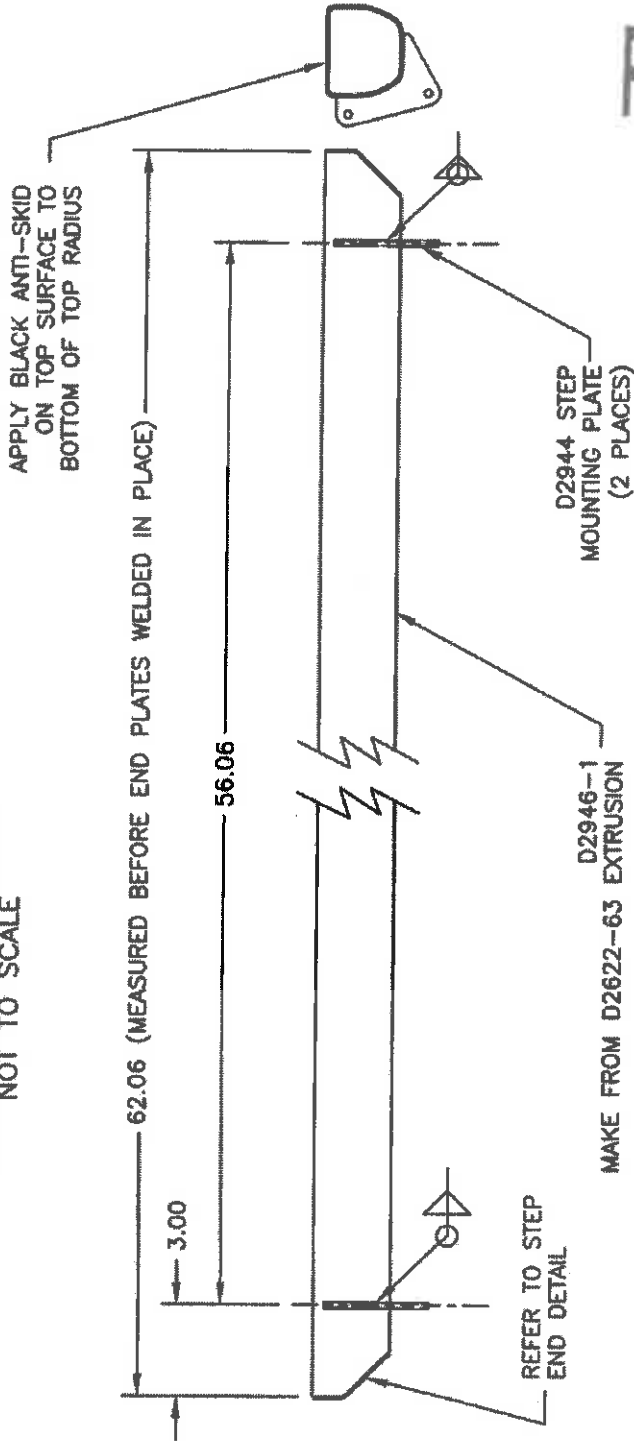
Part No.	Description	QTY
D2946	Step Assembly	1
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

*cut per drawing

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE



D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5.0 PARTS LIST

Qty -117A	Qty -119	Qty -120	Part Number	Description
X			D350-591-117A	Half-Access-Step™, Pre-Flight Step
	X		D350-591-119	Half-Access-Step™, Long Step – Low Skid
		X	D350-591-123	Half-Access-Step™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2846-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2945	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		3	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
2			MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	Half-Access-Step™, Short Step – High Skid, LH
	X			D350-591-122	Half-Access-Step™, Short Step – High Skid, RH
		X		D350-591-123	Half-Access-Step™, Short Step – Low Skid, LH
			X	D350-591-124	Half-Access-Step™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT